



Dart Aerospace Ltd.
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D4149-5
Job Sheet 194849



Part No: D4149-5

Job Qty: 20 pcs *40*

Part Name: Eyebolt Stud



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/9/19

Job Tracking No:

Due Date: 6/26/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP Rev:B 11.03.03 as per revC DD
verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Doosan - 1	20 pcs	6/26/19	6/26/19	0.00	10.00	Doosan - 1	
120	QC 8	20 pcs	6/26/19	6/26/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
150	Packaging 3-1 - Stock - B4B	20 pcs	6/26/19	6/26/19	0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	



Container No: S187797



Part: D4149-5

Job No: 194849

Serial No/Batch: S187797

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/05/19

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160	QC 21 - SA	20 pcs	6/26/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - (Doosan Lathe) turn as per dwg and folio FA950
 Descriptions: 120 - (QC8- Inspect parts - second check)
 150 - Identify as per dwg & Stock Location: _____
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R1.000	303 Round Bar 1.00	5 ft (.25 ea)	100-Doosan - 1	3178000 5156621

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R1.000	5	69	0

1,4444

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt Stud	0.250Inches + 0.003 - 0.000	0.253 0.250	Diameter	.2515
2	Eyebolt Stud	1.380Inches ± 0.030	1.410 1.350		1.379
3	Eyebolt Stud	0.400Inches + 0.000 - 0.010	0.400 0.390		.3955
4	Eyebolt Stud	0.700Inches + 0.010 - 0.000	0.710 0.700		.706
5	Eyebolt Stud	0.030Inches ± 0.010	0.040 0.020	Radius	R1/32
6	Eyebolt Stud	0.375Inches + 0.000 - 0.020	0.375 0.355	Diameter	.366
7	Eyebolt Stud	0.700Inches + 0.000 - 0.010	0.700 0.690	Diameter	.6955
8	Eyebolt Stud	0.200Inches ± 0.010	0.210 0.190		.202
9	Eyebolt Stud	1.500Inches ± 0.010	1.510 1.490		1.5
10	Eyebolt Stud	0.060Inches ± 0.030	0.090 0.030	Radius	R1/16
11	Eyebolt Stud	2.880Inches ± 0.030	2.910 2.850		2.88
12	Eyebolt Stud	0.310Inches ± 0.010	0.320 0.300		.311
13	Eyebolt Stud	0.750Inches + 0.003 - 0.000	0.753 0.750		.752
14	Eyebolt Stud	0.750Inches ± 0.030	0.780 0.720		.745
15	Eyebolt Stud	0.735Inches ± 0.010	0.745 0.725		.738

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			